

WORK ORDER 2011-44

Date opened: 17 October 2011

Project: Quick Release XL-Long Cargo Basket Assembly (Prototype)  
Type: Bell 206L Series, 407

Batch Quantity: 1 Complete Basket Assembly (94610-01)

Approval: SH00-48  
Drawing List: DCL946-10, DCL704

Fabrication and Assembly Drawing(s)	Description
94610, Rev. 0	Basket Ass'y
94611, Rev. 0	Basket Body Ass'y
94612, Rev. 0	Basket Lid Ass'y
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70405, Rev. 3	Lid Step Modification
70422, Rev. 0	Gas Spring Provisions Mod.

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y ✓</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y ✓</u>
Drawings revision levels match Document Control List:	<u>Y ✓</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y ✓</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y ✓</u>
Release tags associated with all fabricated parts are attached:	<u>Y ✓</u>
All mounting hardware and supplies are included:	<u>Y ✓</u>

List all non-conformities raised: \_\_\_\_\_

Welder Signature:

Date:



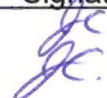
30 Nov 2011

Inspector Signature:

Date:

Drawing: **94610** Revision **0**  
 Assembly: **94610-01** **Cargo Basket Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	94610-01	Cargo Basket Assembly			
1	94611-01	Basket Body Assembly	Below		
1	94612-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	11078	
1	MS20001P4	Piano Hinge		11014	
1	69827-01	Placard	0.050" Sheet, 6061-T6 Aluminum	11102	
4	49205-14	Bumper	Argus Industries Bumper	11010	
A/R	CR3213-5-02	Blind Rivet		10089	
8	CR3523-5-02	Monel Blind Rivet		11061	
4	CR3213-4-02	Blind Rivet		10089	
4	40088-14	Fitting	Ancra	11012	
4	AN960-616	Washer		11077	
1	AN3-15A	Bolt		11077	
1	AN3-17A	Bolt		11077	
4	AN960-10	Washer		11088	
2	AN970-3	Washer		11052	
2	MS21044N3	Nut		11088	
1	94621-01	Brace		8089	
2	AN4-7A	Bolt		8078	
2	AN4-30A	Bolt		11116	
4	AN960-416	Washer		11095	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-5-02, CR3523-5-02 Rivets, CR3213-4-02		

Final Inspection Drawing 94610

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **94611** Revision 0  
 Assembly: **94611-01** Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	94611-01	Basket Body Assembly			
A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	11049	
A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11049	
3	94520-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	11049	
1	94521-01	Forward Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	11049	
1	94522-01	Aft Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	11049	
2	94620-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	11049	
4	69823-02	Lug	1018 Mild Steel, 5/8" Rod	10087	
4	94621-01	Insert	1018 Mild Steel, 3/8" Rod	8011	
1	84262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	7007	
A/R	3/4-16F	Mesh	Expanded carbon steel	10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94611			
Final Inspection	Drawing 94611			

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Drawing: 94512 Revision 0  
Assembly: 94512-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	94612-01	Basket Lid Assembly			
A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11049	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	7007	
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94612			
Final Inspection	Drawing 94612			

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Drawing: **84255**      **Revision 1**  
Assembly: **84255-01**      **Handle Installation**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2011-20	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	11041	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
2	AN3-12A	Bolt		11077	
4	AN3-11A	Bolt		11052	
12	AN960-10	Washer		11088	
6	MS21044N3	Nut		11088	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

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Drawing: **84261**      **Revision 1**  
Assembly: **84261-01**      **Handle Bar Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10083	
2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
2	MS20615-4M3	Monel Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

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Drawing: **84262**      **Revision 1**  
Assembly: **84262-01**      **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bracket Assembly			
4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Tube	11049	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			


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Drawing: **70405**      **Revision 2**  
Assembly: **70405-01**    **Lid Step Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	70405-01	Lid Step Modification			
A/R	70405-03	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11049	
A/R	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	11055	
A/R	CR3213-4-2	Cherry Rivet		10089	

Note: Remainder of assembly listed on drawing 94612

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

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Drawing: **70422**      **Revision 0**  
Assembly: **70422-01**      **Gas Shock Provisions Modification**

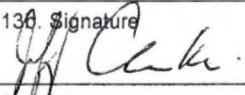
Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	70422-01	Gas Shock Provisions Modification			
2	70422-04	Bushing	304 Stainless Steel, 5/16" x 0.058 tube	7102	
1	70422-05	Spacer	304 Stainless Steel, 1/2" Rod	8096	

Note: Remainder of assembly listed on drawing 94611 and 94612

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 70422			

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1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 2013 39<sup>th</sup> Avenue NE, Calgary, Alberta, T2E 6R7</b>					5. Work Order/Contract/Invoice <b>2011-44</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>94610-01</b>	<b>1</b>	<b>94601-01</b>	<b>New</b>	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke</b>		13e. Date (dd/mmm/yyyy) <b>30 Nov 2011</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

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